

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011327**Date Inspected:** 19-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

CWI Inspectors: Mr. Zhu Tian Shu Mr. Wang Chuan Qing

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG BAY 2

This QA Inspector observed ZPMC welder Mr. Xu Fubao, stencil 200569 is using shielded metal arc process WPS-B-P-2112 to tack weld OBG longitudinal diaphragm fillet weld LD3024-001-012. This QA Inspector observed a welding current of approximately 180 amps, the base material is being preheated with a torch and Mr. Xu Fubao appears to be certified to make this weld. This QA Inspector observed the shielded metal arc welding electrodes are being stored in an electrically heated electrode storage container which is warm to the touch. Items observed on this date appeared to generally comply with applicable contract documents.

OBG BAY 5

This QA Inspector observed ZPMC workers using air carbon arc gouging equipment to remove portions of traveler rail welds 1TR1-027-014 in accordance with welding repair report BWR9168, weld 10TR3-10-014 in accordance with welding repair report BWR-9160 and weld 10TR1-017-014 in accordance with welding repair

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report BWR-9164. These weld removals were being monitored by QC CWI Mr. Liu Fa Wen. This QA Inspector did not observe any ZPMC personnel performing welding repairs of any of these welds during this shift. Items observed on this date appeared to generally comply with applicable contract documents.

Tower Bay 10

This QA Inspector observed ZPMC welder Mr. Gao Qiang, stencil 057258 is using welding procedure WPS-B-T-2113 to make a shielded metal arc fillet weld on shear link weld EDI-A6003-5-031. The QA Inspector observed a welding current of approximately 185 amps. The QA Inspector observed ZPMC has used electric heaters to preheat the base material adjacent to where the weld was being deposited. Items observed by the QA Inspector appear to comply with project specifications.

This QA Inspector observed ZPMC welder Mr. Jiang Taian, stencil 050038 is using welding procedure WPS-B-T-2113 to make a shielded metal arc fillet weld on shear link weld EDI-A6003-5-020. The QA Inspector observed a welding current of approximately 170 amps. The QA Inspector observed ZPMC has used electric heaters to preheat the base material adjacent to where the weld was being deposited. Items observed by the QA Inspector appear to comply with project specifications.

Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
